

Date: Tuesday, 20/05/2008 11:40:18 AM  
 User: Melanie Fauteux

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: LID PRO ARM ASSEMBLY (SHORT)		
Job Number	39332	Part Number	: D2332041		
Estimate Number	10258	Drawing Number	: D2332		
P.O. Number	:	Project Number	: N/A		
This Issue	20/05/2008	S.O. No.	:		
Prsht Rev.	NC	Type	: SMALL /MED FAB		
First Issue	/ /	Material	:		
Previous Run	38797	Due Date	27/05/2008	Qty:	20 Um: Each
Written By	:				
Checked & Approved By	:	<i>MF.</i>			
Comment	: Est: B 02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5KJ/ RF				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR1000W049	304 RD Tube 1.0" x .049W	
		Comment: Qty.: 0.4331 f(s)/Unit Total : 8.6625 f(s) Material: 1.000" OD x 0.049" wall SS Tube (Seamless)	<i>M107950</i> Batch <i>E08/05/22</i>
2.0	M304R250	1/4" 304 SS Roundbar	
		Comment: Qty.: 0.1092 f(s)/Unit Total : 2.1840 f(s) Material: Ø0.250" 304SS Rod	<i>M107387</i> Batch <i>E08/05/22</i>
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1	<i>E08/05/22</i>
		1-Cut to length as per Dwg D2332 (D2332-7) Locking Collar	<i>3</i>
		2-Cut to length as per Dwg D2332 (D2332-5) Stop Pin	<i>E08/05/22</i>
		3-Deburr	<i>20</i>
4.0	M304TR0500W035	304 RD Tube .500 x .035W	
		Comment: Qty.: 1.2502 f(s)/Unit Total : 25.0040 f(s) 304 RD Tube .500 x .035W	<i>M107967</i> <i>SD 08/05</i>

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Part Number: D2332041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

Punch or form to length as per Dwg D2332 (D2332-11) using DT8012

(Note: Make (2) D2332-11 Prop Arms per assembly.)

SB 08/05/20 20

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill hole in D2332-11 as per Dwg D2332 using Drill Jig DT8459. (Drill 1 per assembly)

2-ensure no foreign objects inside fo tube and deburr

BB 08/05/20 20

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

So 08/05/22

720 820 720 720 720

8.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld D2332-11 and D2332-5 as per Dwg D2332 using Welding Jig DT8298. (Weld 1 per assembly) \*\*\*\*\*  
insure nothing is inside of tube before welding\*\*\*\*\*

20X

A/R SS Rod Batch: M107051

08-06-2. 8

9.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Mo 08/06/20 20

10.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

So 08/06/22 720

11.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Assemble as per Dwg D2332

EF 08/06/20 20

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Part Number: D2332041

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 AN44A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN4-4A	Bolt	M106918

13.0 AN960JD416L Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
3	AN960JD416L	Washer	M107008

14.0 MS21042L4 Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS21042L4	Nut (or -4)	M107478

15.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/06/03 (20)

16.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

10/06/03 (20)

17.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/03 (20)

Job Completion

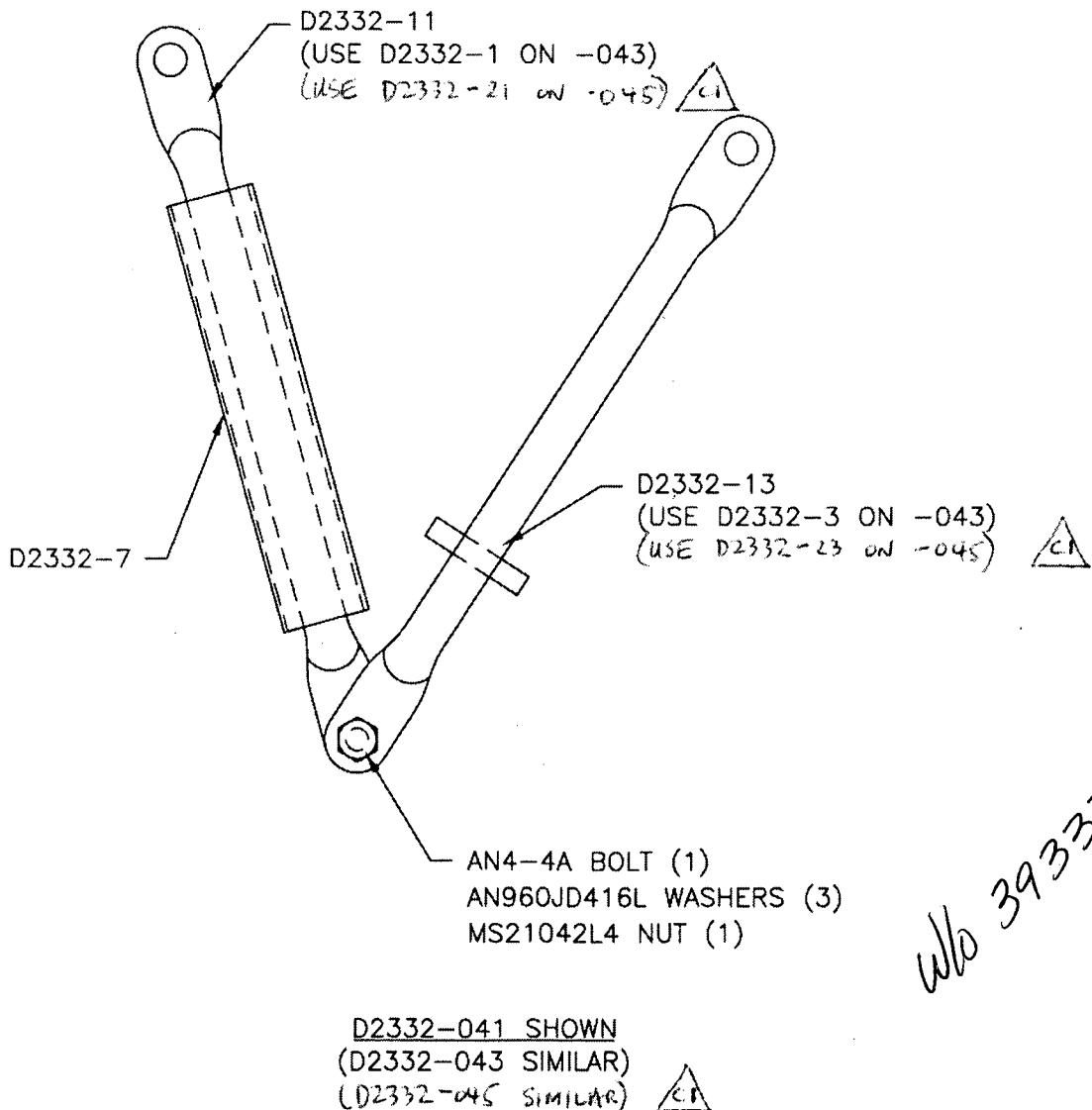


10/06/03 (20)

**DART**

copy issue  
DRAFT

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D2332	SHEET 1 OF 2
DATE		TITLE	SCALE
03.07.03		LOD PROP ASSEMBLY	NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	03.08.06	ADD -045 PROP (7.25" LONG)	



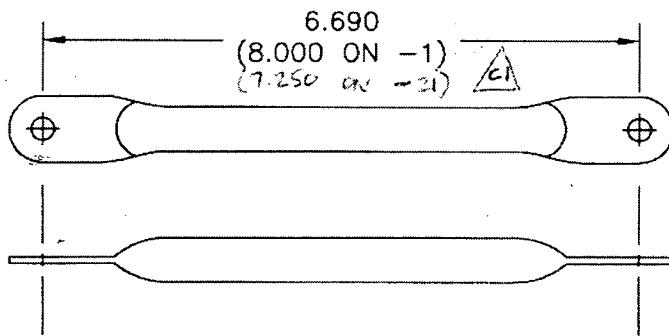
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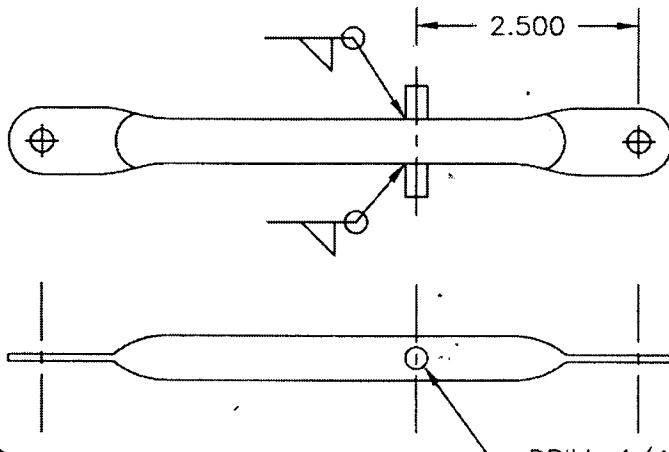
**DART**

DAC COPY  
DRAFT

DESIGN	DRAWN BY	DART AEROSPACE LTD
<del>11</del>	<del>JL</del>	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D2332
DATE		SHEET 2 OF 2
03 07.03		
TITLE		SCALE
LID PROP ASSEMBLY		1:2
C	03 07.03	MATERIAL - 0.500 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035 0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250 1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
C1	03 08.06	ADD - 045 PROP (7.25" LONG)

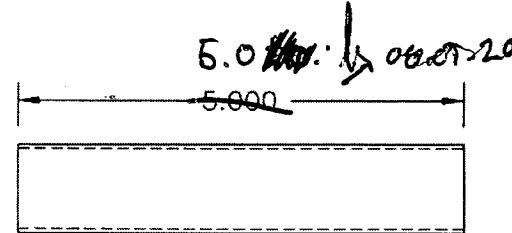


D2332-11 PROP  
(D2332-1 SIMILAR)

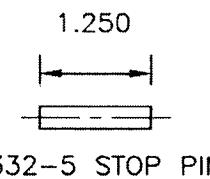


D2332-13  
M/F D2332-11 & D2332-5

(D2332-3 SIMILAR - M/F D2332-1 & D2332-5)  
(D2332-23 SIMILAR - M/F D2332-21 & D2332-5)



D2332-7 LOCKING COLLAR



D2332-5 STOP PIN

NOTES:

1. MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035  
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250  
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
2. TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13